

Ship Aug 21

Work Order ID 135258

135258

Page 1

Friday, August 07, 2015 2:45:15 PM

Item ID: D119-796-031 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 8/10/15 Start Qty: 1.00 *1*

Required Date: 8/21/15 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Y Date: 158.7 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN-D119-796	REV A	J.A

100 Pick Kit 0.00 ① J.A AUG 17 2015

100

Packaging

Memo

0.00

Packaging

Photocopy bluefile and create labels as per PPP D119-796-031 chg 001

/ 2 per ELN 15-580

110

0.00

110

HandFinish

Memo

0.00

Hand Finishing

ASSEMBLE AS PER DWG AND NOTES 8,9,10,11

2-INSTALL DECAL D2729-4

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

① 1508-08

DAS
9
9-89DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 135258

Friday, August 07, 2015 2:45:15 PM

135258

Page 2

Item ID: D119-796-031 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible
Start Date: 8/10/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/21/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>Ship</i>	0.00				<i>1X</i>			<i>15/09/09</i>
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140						<i>mc</i>		<i>SEP 09 2015</i>	
QC	Memo	0.00							
Quality Control	Identify and pack for shipping as per PPP D119-796-031								
	Location: _____								
	PPP Rev: _____								

5th 20150909

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER :					

Picklist Print

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Page 1

Work Order ID: 135258

135258

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 8/10/15

Required Date: 8/21/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-05-12 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-043		Manufactured	No				Each	0.0000		2			
D119-646-043													
Repl. Skidtube with Wearpads, DART (Apical) Tri-Bag Float Compatible, Fits LH/RH													
D119-796-151		Manufactured	No				Each	0.0000		1			
D119-796-151													
FWD Crosstube Installation with Step (no hardware)													
D119-796-251		Manufactured	No				Each	0.0000		1			
D119-796-251													
AFT Crosstube Installation with Step (no hardware)													
D2652		Manufactured	No				Each	339.0000		48			
D2652													
Bushing													

Location	Loc Qty	Loc Code
FG	45	
31985	45	
ST009	252	
15133	16	
129993	17	
133178	18	
134494	201	
ST012a	42	
123711	32	
124422	2	
8905	8	

D3407-041

Manufactured No

Each 0.0000

2

D3407-041

Tow Ring

B133096

**

JA

AUG 18 2015

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Work Order ID: 135258

135258

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 8/10/15

Required Date: 8/21/15

Start Qty: 1.00

Required Qty: 1.00

D3417-5 Manufactured No

Each 59.0000 4

D3417-5

**** JA**

Washer

Location	Loc Qty	Loc Code
ST038A	59	
131054	19	4
133476	40	

D3456-1 Manufactured No

Each 96.0000 2

D3456-1

**** JA**

Washer

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST038A	86	
134407	86	
ST051A	3	2
128456	3	

D3672-3 Manufactured No

Each 599.0000 48

D3672-3

**** J.A .**

AUG 18 2015

Washer, Phenolic

Location	Loc Qty	Loc Code
FG	100	
133083	100	
FP001	263	
132639	263	
ST049	221	
134449	221	
ST055	15	48
129916	15	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Work Order ID: 135258

135258

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 8/10/15

Required Date: 8/21/15

Start Qty: 1.00

Required Qty: 1.00

D3672-7

Manufactured No

Each

930.0000

48

D3672-7

Washer, Phenolic

**

J.A.

Location

Loc Qty

Loc Code

FG

25

129987

25

ST049

500

134786

500

ST055

405

120476

6

129987

39

133986

360

48

D3883-1

Manufactured No

Each

4.0000

2

D3883-1

Saddle, Outboard LH

**

J.A.

Location

Loc Qty

Loc Code

ST404

4

133784

4

2

D3883-2

Manufactured No

Each

3.0000

2

D3883-2

Saddle, Outboard RH

**

J.A.

Location

Loc Qty

Loc Code

ST404

3

133203

3

1

D3884-1

Manufactured No

Each

4.0000

2

D3884-1

Saddle, Inboard LH

**

J.A.

AUG 18 2015

Location

Loc Qty

Loc Code

ST404

4

133099

4

2

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Work Order ID: 135258

135258

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 8/10/15

Required Date: 8/21/15

Start Qty: 1.00

Required Qty: 1.00

D3884-2 Manufactured No

Each 1.0000 2

D3884-2

Saddle, Inboard RH

**** JA**

Location

Loc Qty

Loc Code

ST404

1

133606

1

D3886-041 Manufactured No

Each 4.0000 2 4

D3886-041

Lug Assembly

**** JA**

Location

Loc Qty

Loc Code

ST528

4

133788

4

AN3C46A Purchased No

Each 149.0000 8

AN3C46A

Bolt

**** JA AUG 17 2015**

Location

Loc Qty

Loc Code

FG

10

122843

10

ST338a

70

M132169

70

ST346

69

131651

35

M132522

34

m131651

8

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Shop Packet Print

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			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, August 07, 2015 2:45:22 PM

Work Order ID: 135258

***135**

Parent Item: D119-796-031

***D11**

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Pro

Needs to pick this.

AN3C50A

Purchased

No

AN3C50A

Bolt

Lo
ST
ST

131651

1

M132381

8

M132674

7

AN4C6A

Purchased

No

AN4C6A

Bolt

Each

234.0000

JA

AUG 17 2015

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

ST312A

120

m132853

120

ST345

100

m131410

100

ADD MS21920-28 x 2 B 132381
AN3C45A x 12 *B M122843
NAS1149C0332R M130325 (24x)
MS21043-3 M132551 (12x)

per ECN 15-580
EP 15/09/08

16

JA

16

7

24

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Page 6

Friday, August 07, 2015 2:45:23 PM

Work Order ID: 135258

135258

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 8/10/15

Required Date: 8/21/15

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

Each

638.0000

24

MS21043-3

JA

Nut

Location

Loc Qty

Loc Code

FG 80

103691 80

FP001 11

m130673 11

GA 191

m130673 15

m131677 176

ST304 199

m131340 199

ST308 157

m132551 157

24

MS21043-4

Purchased

No

Each

754.0000

26

MS21043-4

JA

Nut

Location

Loc Qty

Loc Code

FG 40

104603 40

GA 193

m128798 193

ST273A 300

m132803 300

ST304 221

m128818 39

m131697 9

m132382 4

m132536 169

26

AUG 17 2015

Friday, August 07, 2015 2:45:23 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 7

Friday, August 07, 2015 2:45:23 PM

Work Order ID: 135258

135258

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 8/10/15

Required Date: 8/21/15

Start Qty: 1.00

Required Qty: 1.00

MS21043-5

Purchased

No

Each

292.0000

8

***MS21043-5* ***

JA

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

76

116548

76

ST304

196

m129499

4

m132123

4

m132382

188

MS21250-05048

Purchased

No

Each

0.0000

8

***MS21250-05048* ***

JA

BOLT (use MS21250-05-048)

NAS1149C0332R

Purchased

No

Each

3,005.000

8

24

NAS1149C0332R

JA

WASHER

AUG 17 2015

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

221

m131618

221

ST271

644

m129390

72

m132262

572

24

Friday, August 07, 2015 2:45:23 PM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Page 8

Friday, August 07, 2015 2:45:23 PM

Work Order ID: 135258

135258

Parent Item: D119-796-031

D119-796-031

Parent Item Name: AW119 Landing Gear Assembly - Standard OEM Protection, Float Compatible

Start Date: 8/10/15

Required Date: 8/21/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

Each

1,669.000

48

NAS1149C0432R

JA.

WASHER

Location

Loc Qty

Loc Code

GA

1656

m125807

476

m131467

1180

ST271

13

m131452

13

48

NAS1149C0532R

Purchased

No

Each

198.0000

16

NAS1149C0532R

JA

AUG 17 2015

WASHER

Location

Loc Qty

Loc Code

GA

60

116513

60

ST271

138

m128537

40

m131624

98

16

**DAS
6
9-89**

DSI 9730-011 X1 B: 136781

SEP 09 2015

DQA: _____ Date: _____



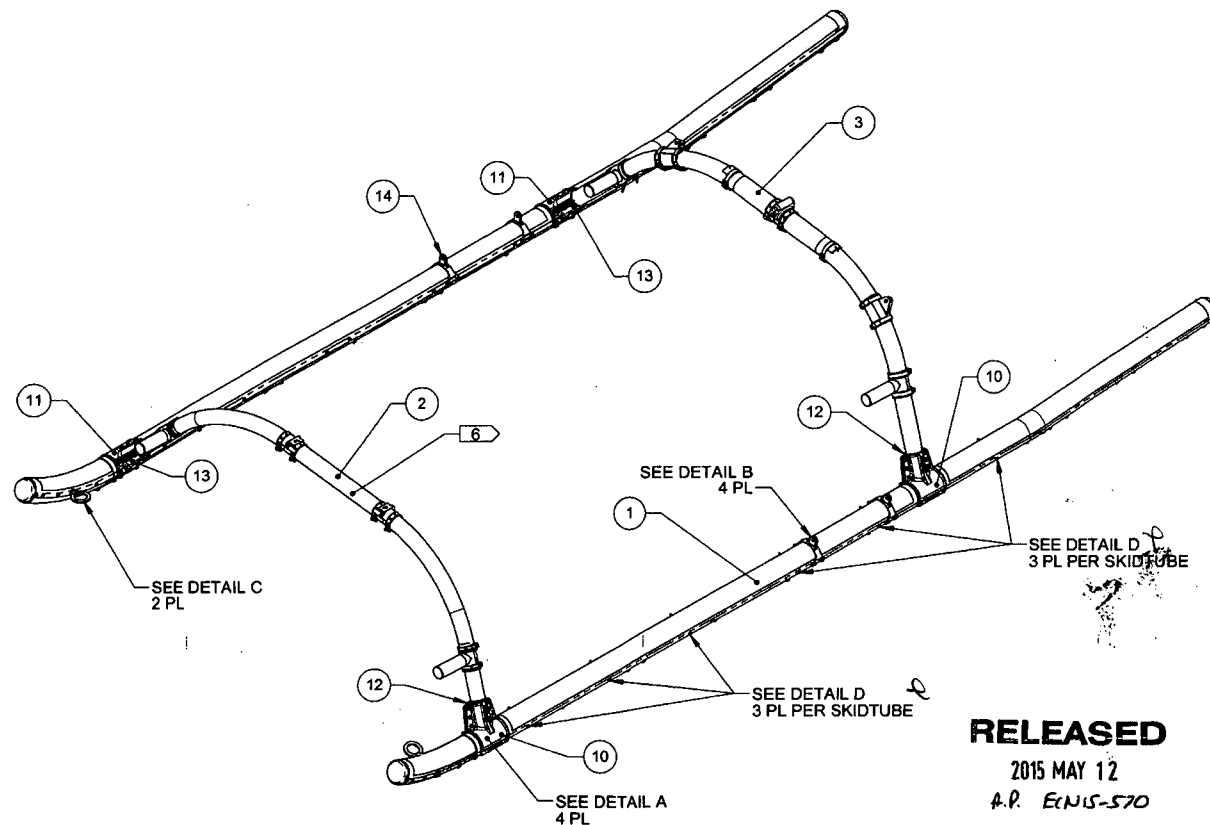
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

ITEM	QTY -031	P/N	DESCRIPTION
	X	D119-796-031	FLOAT GEAR WITH STD WEARPADS
1	2	D119-646-043	FLOAT SKIDTUBE WITH STD WEARPADS
2	1	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
3	1	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
4	48	D2652	BUSHING
5	2	D3407-041	TOW RING
6	4	D3417-5	WASHER
7	2	D3456-1	WASHER
8	48	D3672-3	PHENOLIC WASHER
9	48	D3672-7	PHENOLIC WASHER
10	2	D3883-1	SADDLE, OUTBOARD LH
11	2	D3883-2	SADDLE, OUTBOARD RH
12	2	D3884-1	SADDLE, INBOARD LH
13	2	D3884-2	SADDLE, INBOARD RH
14	4	D3886-041	LUG ASSEMBLY
15	12	AN3C45A	BOLT
16	8	AN3C46A	BOLT
17	16	AN3C50A	BOLT
18	24	AN4C6A	BOLT
19	36	MS21043-3	NUT, SELF-LOCKING
20	26	MS21043-4	NUT, SELF-LOCKING
21	8	MS21043-5	NUT, SELF-LOCKING
22	8	MS21250-05048	BOLT
23	48	NAS1149C0332R	WASHER
24	48	NAS1149C0432R	WASHER
25	16	NAS1149C0532R	WASHER



D119-796-031 FLOAT GEAR WITH STD WEARPADS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
- 7) WEIGHT: 135.5 LBS

Handwritten: 15-8-7
135258

A NEW ISSUE		AP	15.04.01
REV.	DESCRIPTION		BY DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-031 REV. A SHEET 1 OF 5 TITLE FLOAT GEAR WITH STD WEARPADS NTS SCALE DATE 15.04.01	
DRAWN	AP		
CHECKED	CP		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED

2015 MAY 12

A.P. ENUS-570

MS21250-05048 BOLT
NAS1149C0532R WASHER
D3672-7 WASHER
2 PL
10

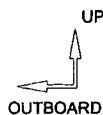
D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)

D3884-1 SADDLE (LHS)
D3884-2 SADDLE (RHS)

D3672-7 WASHER
NAS1149C0532R WASHER
MS21043-5 NUT
2 PL
10

D2652 BUSHING
D3672-7 WASHER
NAS1149C0332R WASHER
MS21043-3 NUT
4 PL
10

DETAIL A
4 PL



AN4C6A BOLT
NAS1149C0432R WASHER
D3672-3 WASHER (2)
NAS1149C0432R WASHER
MS21043-4 NUT
6 PL
9

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)
REF

DETAIL A
4 PL



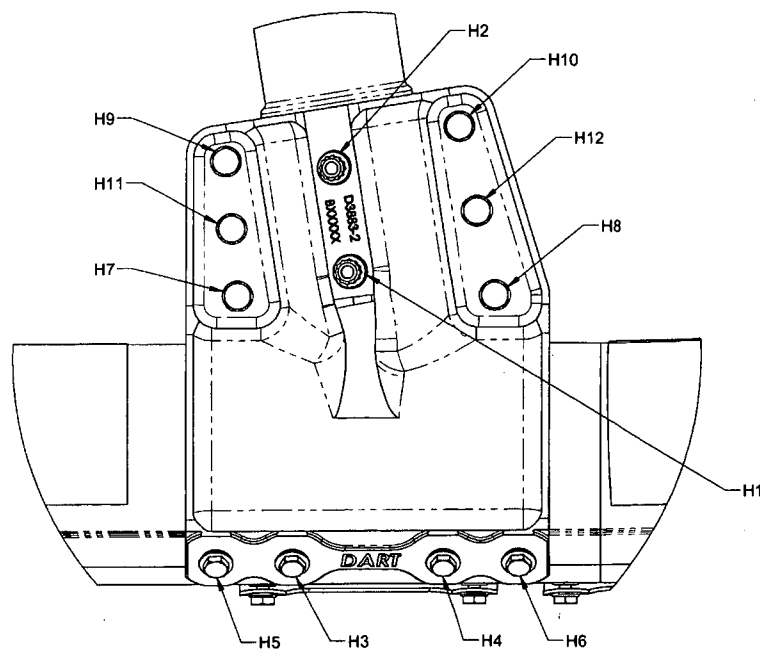
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
 - A) ALONG SADDLE/CROSSTUBE INTERFACE
 - B) BETWEEN THE SADDLE FLANGES
 - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

RELEASED
A.P. 2015 MAY 12

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO. D119-796-031	REV. A
MFG. APPR.	DD		SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOAT GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 N-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 N-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)

RELEASED

A.P. 2015 MAY 12

APPROVED	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	CP	DRAWING NO.	REV. A
	MFG. APPR.	DD	D119-796-031	SHEET 3 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DSS	FLOAT GEAR WITH STD WEARPADS	NTS
	DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

C

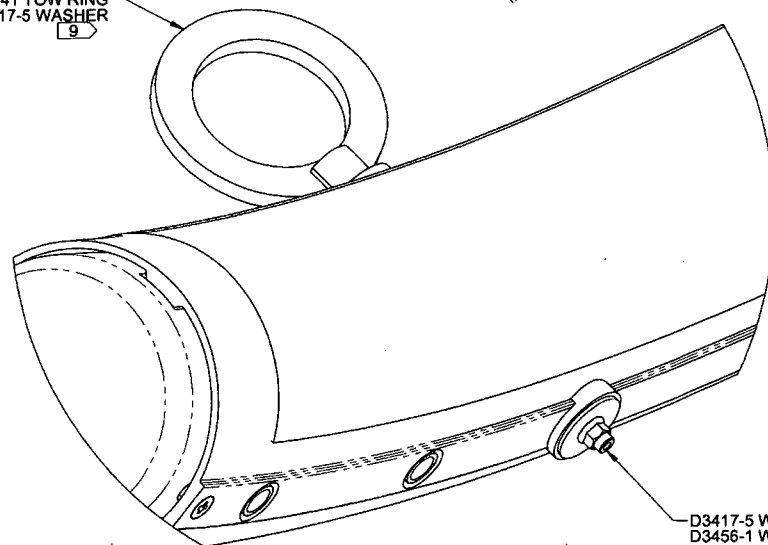
B

A

D3407-041 TOW RING
D3417-5 WASHER

9

INBOARD



D3417-5 WASHER
D3456-1 WASHER
MS21043-4 NUT

8 9 11

DETAIL C
2 PL

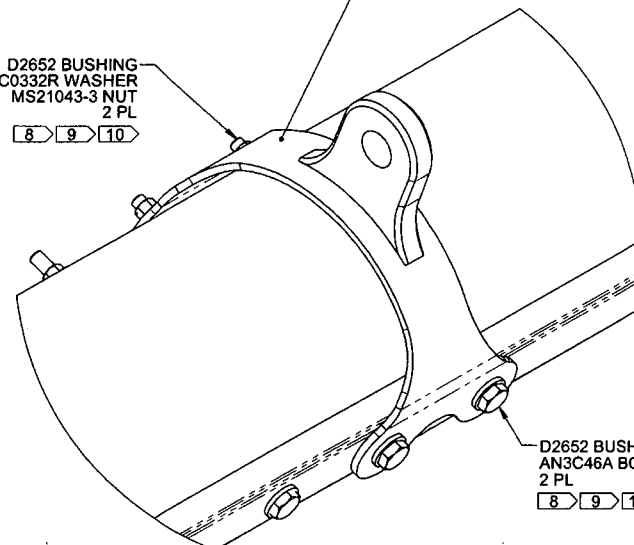
D2652 BUSHING
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

8 9 10

D3886-041 LUG ASSEMBLY

9

INBOARD



D2652 BUSHING
AN3C46A BOLT
2 PL

8 9 10

DETAIL B
4 PL

RELEASED

15.04.01 MAY 12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) APPLY FAY SEAL AND FILLET SEAL USING SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 10) TORQUE AN3 HARDWARE TO 20-25 IN-LBS
- 11) TORQUE AN4 HARDWARE TO 50-70 IN-LBS

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-031	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOAT GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1